

5/17

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22928
<b>Description:</b> Tire and Rim Assembly	<b>Part Number:</b>	D3233-9
<b>Dwg:</b> D3233 Rev. B	<b>Qty:</b>	8
<b>Ref:</b>		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.04.06	8
2	PG	Issue P/O: _____ For D3233-9 Tire and Rim Assembly P/N: 8353T74 Possible Supplier: McMaster-Carr <b>Product Specification sheet is required</b>			
3	RG	Receive and Inspect for transit damage <b>Ensure Product Specification sheet is attached</b>			
4	ST	Identify and Stock			
5	AC	Cost / part: <u>0</u> Closed	AK	05/06/27	
6	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.03.03	New issue	KJ/JLM	<i>[Signature]</i>

**RELEASED**  
7/1/05 03:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

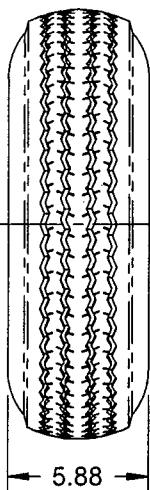
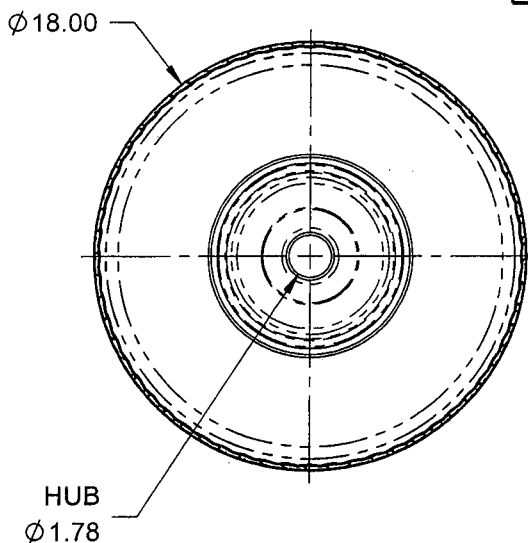
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

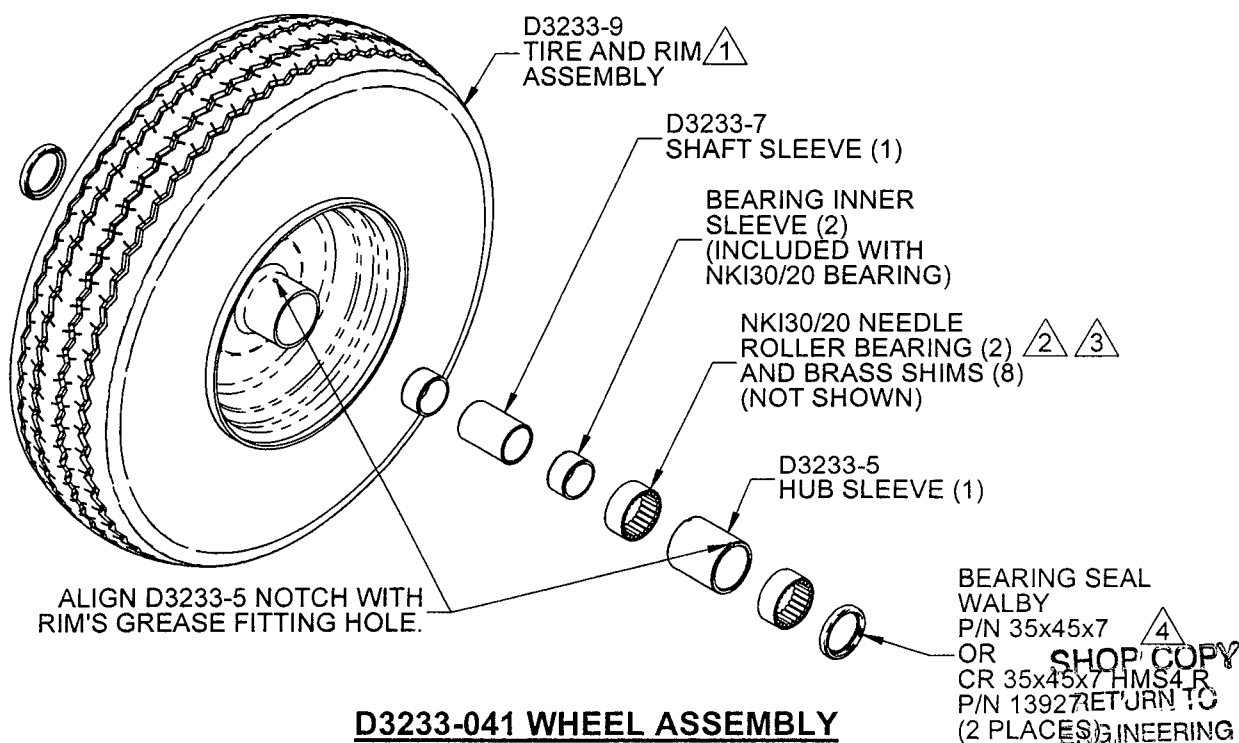
# PRELIMINARY ISSUE

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3233</b>	REV. B SHEET 1 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

\* MANUFACTURER'S RECOMENDATIONS ARE 75 PSI FOR HIGH SPEED USE.



## NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH  
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE

WORK ORDER

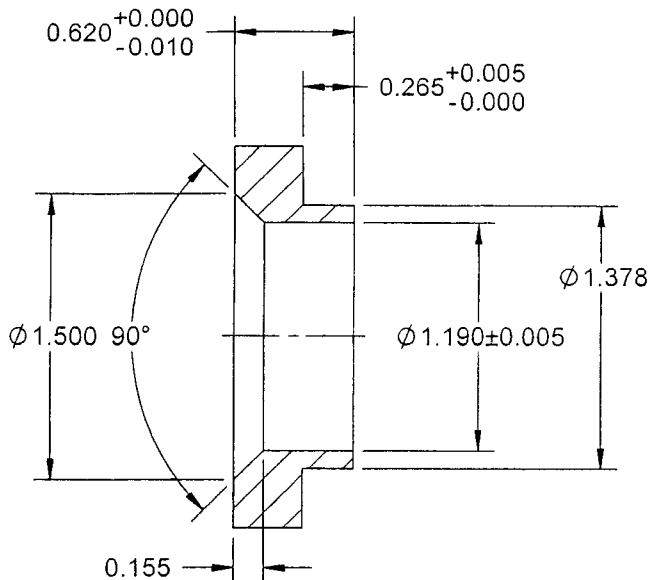
NO. 22328

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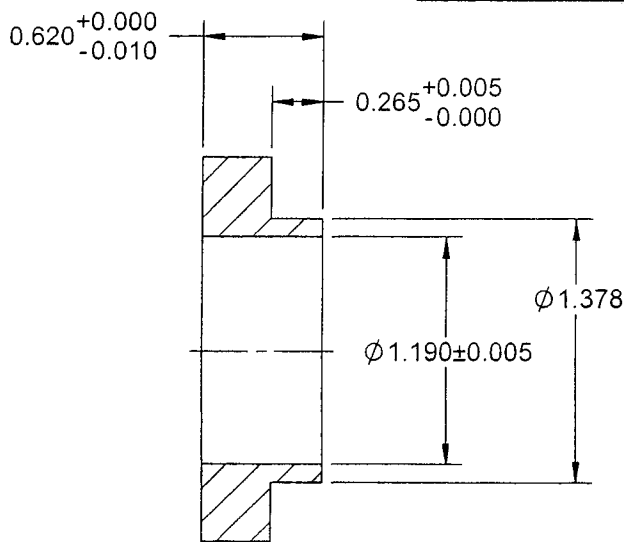
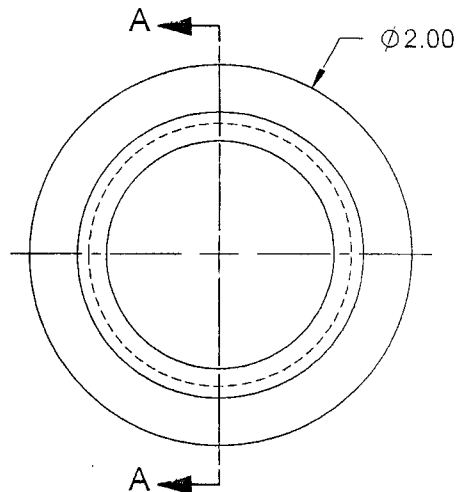
# PRELIMINARY ISSUE

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CHECKED	APPROVED	DRAWING NO. <b>D3233</b>	REV. B SHEET 2 OF 3
DATE <b>05.03.08</b>	TITLE <b>WHEEL ASSEMBLY</b>		SCALE 1:1



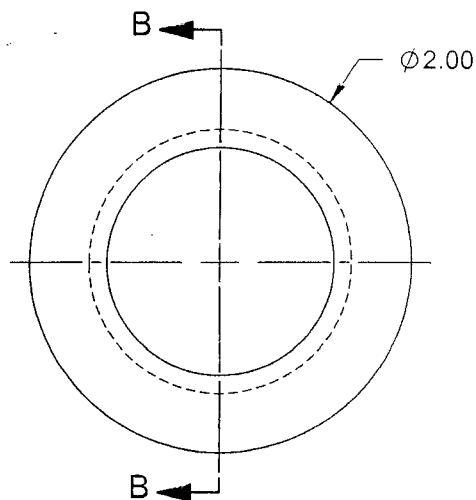
**SECTION A-A**

## D3233-1 INSIDE WASHER



**SECTION B-B**

## D3233-3 OUTSIDE WASHER



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ENGINEERING

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### NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

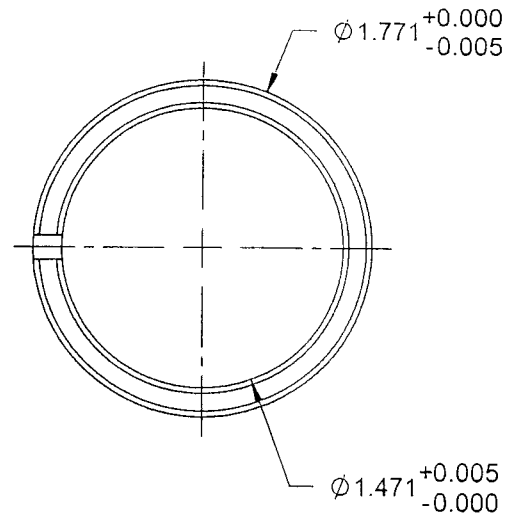
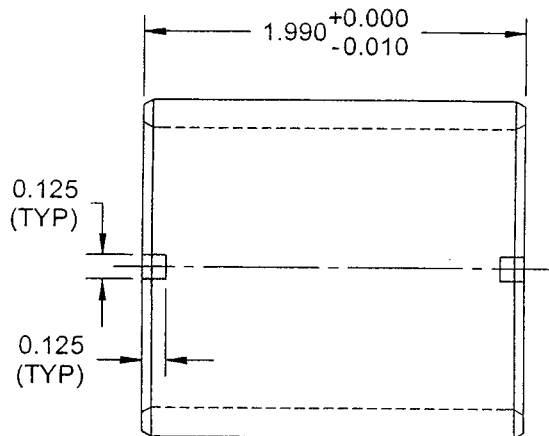
NO. **22928**

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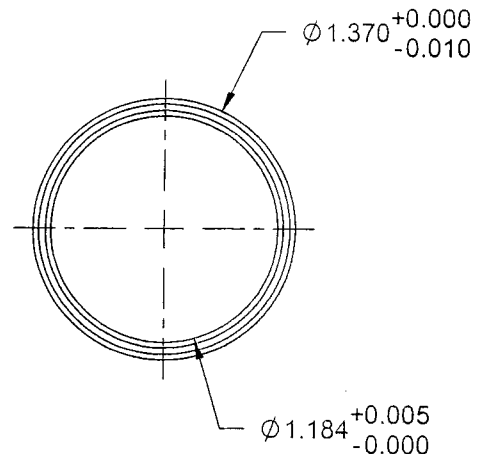
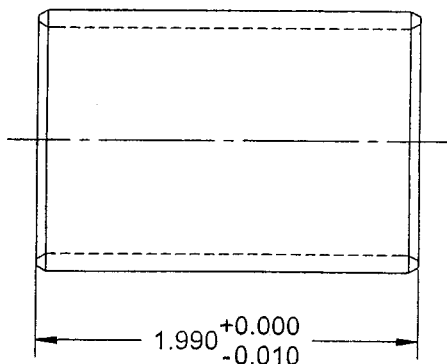
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**PRELIMINARY ISSUE**

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CHECKED	APPROVED	DRAWING NO. <b>D3233</b>	REV. B SHEET 3 OF 3
DATE <b>05.03.08</b>	TITLE <b>WHEEL ASSEMBLY</b>		SCALE 1:1



**D3233-5 HUB SLEEVE**



**D3233-7 SHAFT SLEEVE**

**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS TO AMENDMENT (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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**WORK ORDER**

**NO. 22928**

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 04, 2005  
12:27 pm

Work Order No : 0022928  
Project Name : D3233-9  
Project For : WK517  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3233-9  
Description : Tire & Rim Assembly  
Manufactured : Yes  
Amount Req'd : 8  
Amount Done : 0  
Start Date : 04-04-05  
Est Finish Date : 04-22-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00